

Date: Friday, 30/05/2008 10:12:26 AM  
 User: Julie Lecocq

## Process Sheet

<b>Customer</b> :	CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> :	CABLE GUARD
<b>Job Number</b> :	39591		
<b>Estimate Number</b> :	12456		
<b>P.O. Number</b> :		<b>Part Number</b> :	D29161
<b>This Issue</b> :	30/05/2008	<b>Drawing Number</b> :	D2916 REV B
<b>Prsht Rev.</b> :	NC	<b>Project Number</b> :	N/A
<b>First Issue</b> :	1/1	<b>Drawing Revision</b> :	B
<b>Previous Run</b> :	37550	<b>Material</b> :	
<b>Written By</b> :		<b>Due Date</b> :	10/06/2008
<b>Checked &amp; Approved By</b> :	JLD 08.5.30	<b>Qty:</b>	9 Um: Each
<b>Comment</b> :	Est Rev:A New Issue 06-06-19 JLM Est Rev:B Now water jet 06-07-14 EC		

## Additional Product

Job Number:



<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>
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1.0	MUHMWB10	UHMW 1" Black
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**Comment:** Qty.: 0.4988 sf(s)/Unit Total: 4.9875 sf(s)

UHMW 1" Black

Batch: 108013

B 8-6-5

2.0	WATER JET	FLOW WATER JET
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**Comment:** FLOW WATER JET

1-Cut as per Dwg D2916

Dwg Rev: B

Prog Rev: B

B 8-6-5

①

2-Deburr if necessary

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

B 8-6-5

4.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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**Comment:** HAAS CNC VERTICAL MACHINING #1

BATCH: 108013

1- Mill as per Folio FA2916-1 Rev: B &amp; Dwg D2916 Rev: B

2-Deburr per dwg D2916

H.A/m 08/06/23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Friday, 30/05/2008 10:12:26 AM  
User: Julie Lecocq

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: CABLE GUARD

Job Number: 39591

Part Number: D29161

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

H.A Fmk 08/06/23

6.0

QC8

SECOND CHECK



Comment: SECOND CHECK

080622(9)

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 201

8/6/29

(A) SP

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/07/01

Job Completion



MF 08-06-30

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	39591
<b>Description:</b> Cable Guard		<b>Part Number:</b>	D2916-1
<b>Inspection Dwg:</b> D2916	<b>Rev:</b> B	<b>Page 1 of 1</b>	

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

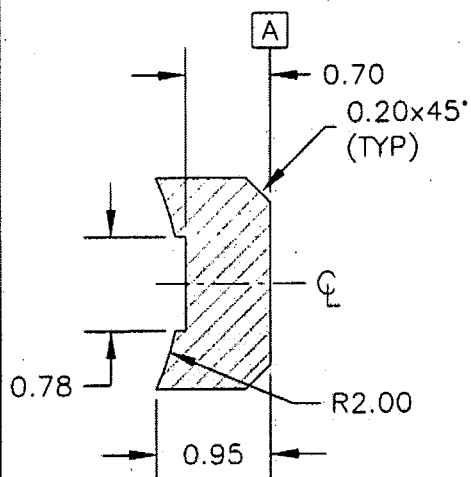
	Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
	1.75	+/-0.030	1.757	* ✓			
	38.94	+/-0.030	38.94	* ✓			
	35.94	+/-0.030	35.940	✓		tape	
	32.25	+/-0.030	32.25	✓		tape	
	29.00	+/-0.030	29.00	✓		tape	
	15.00	+/-0.030	15.00	✓		tape	
	11.31	+/-0.030	11.310	✓			
	3.19	+/-0.030	3.195	✓			
	2.000	+/-0.010	2.005	✓			
	21.125	+/-0.010	21.130	✓			
	37.938	+/-0.010	37.938	✓		tape	
	Ø0.438	+0.005/-0.000	Ø0.438	✓			
	25.00	+/-0.030	25.00	✓		tape	
	24.00	+/-0.030	24.00	✓		tape	
	16.50	+/-0.030	16.50	✓		tape	
	15.01	+/-0.030	15.01	✓		tape	
	3.25	+/-0.030	3.255	✓			
	2.33	+/-0.030	2.335	✓			
A-A	0.78	+/-0.030	0.780	✓			
	0.70	+/-0.030	0.695	✓			
B-B	0.140	+/-0.010	0.142	✓			
	0.360	+/-0.010	0.362	✓			
	0.88	+/-0.030	0.860	✓			
	1.31	+/-0.030	1.310	✓			
C-C	0.78	+/-0.030	0.750	✓			
	0.33	+/-0.030	0.336	✓			
	0.37	+/-0.030	0.370	✓			
D-D	Ø0.438	+0.005/-0.000	Ø0.438	✓			
	Ø0.875	+/-0.010	Ø0.872	✓			
E-E	Ø0.260	+0.005/-0.000	Ø0.260	✓			
	0.37	+/-0.030	0.366	✓			
	Ø0.875	+/-0.010	Ø0.873	✓			
J-J	1.44	+/-0.030	1.438	✓			
	0.063	+/-0.010	0.073	✓			

<b>Measured by:</b> H.A./mk	<b>Audited by:</b> [Signature]	<b>Prototype Approval:</b>	N/A
<b>Date:</b> 08/06/23	<b>Date:</b> 08/06/23	<b>Date:</b>	N/A

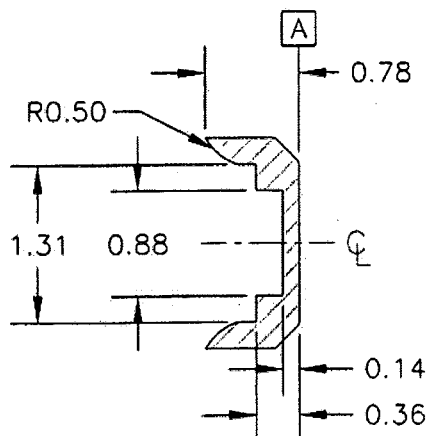
Rev	Date	Change	Revised by	Approved
A	04.01.12	New Issue	P/O D205-665-015	KJ/RF [Signature]



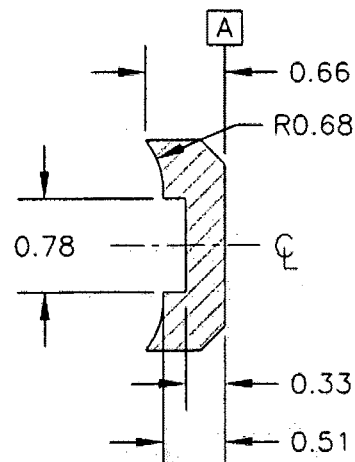
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CHECKED #		APPROVED #		DRAWING NO. D2916	REV. B SHEET 1 OF 2
DATE 00.02.24			TITLE CABLE GUARD SCALE 1:6		
A	99.09.29		NEW ISSUE		
B	00.02.24		ADD K-K FOR D2521 COMPATIBILITY		



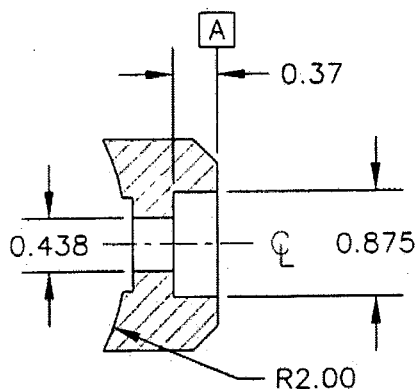
SECTION A-A  
(SCALE 2:3)



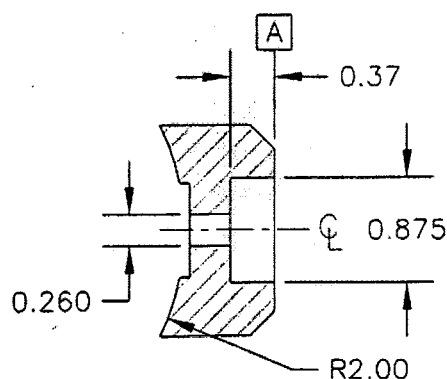
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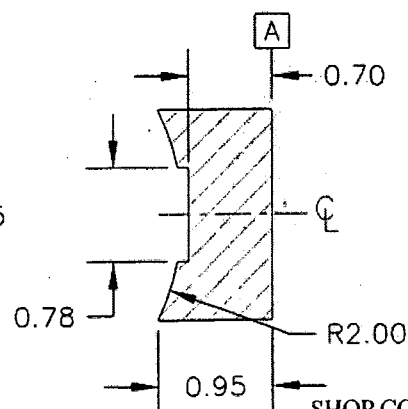
SECTION C-C  
(SCALE 2:3)



SECTION D-D  
(SCALE 2:3)



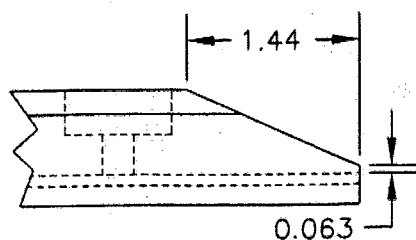
SECTION E-E  
(SCALE 2:3)



SECTION F-

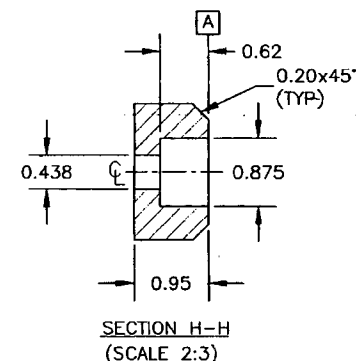
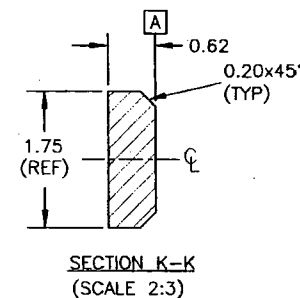
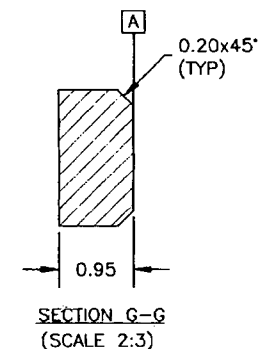
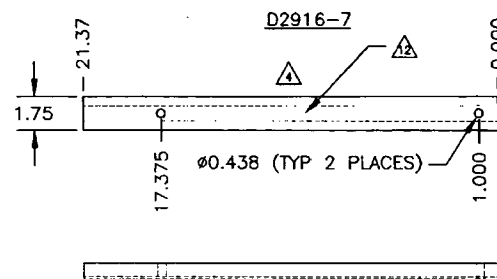
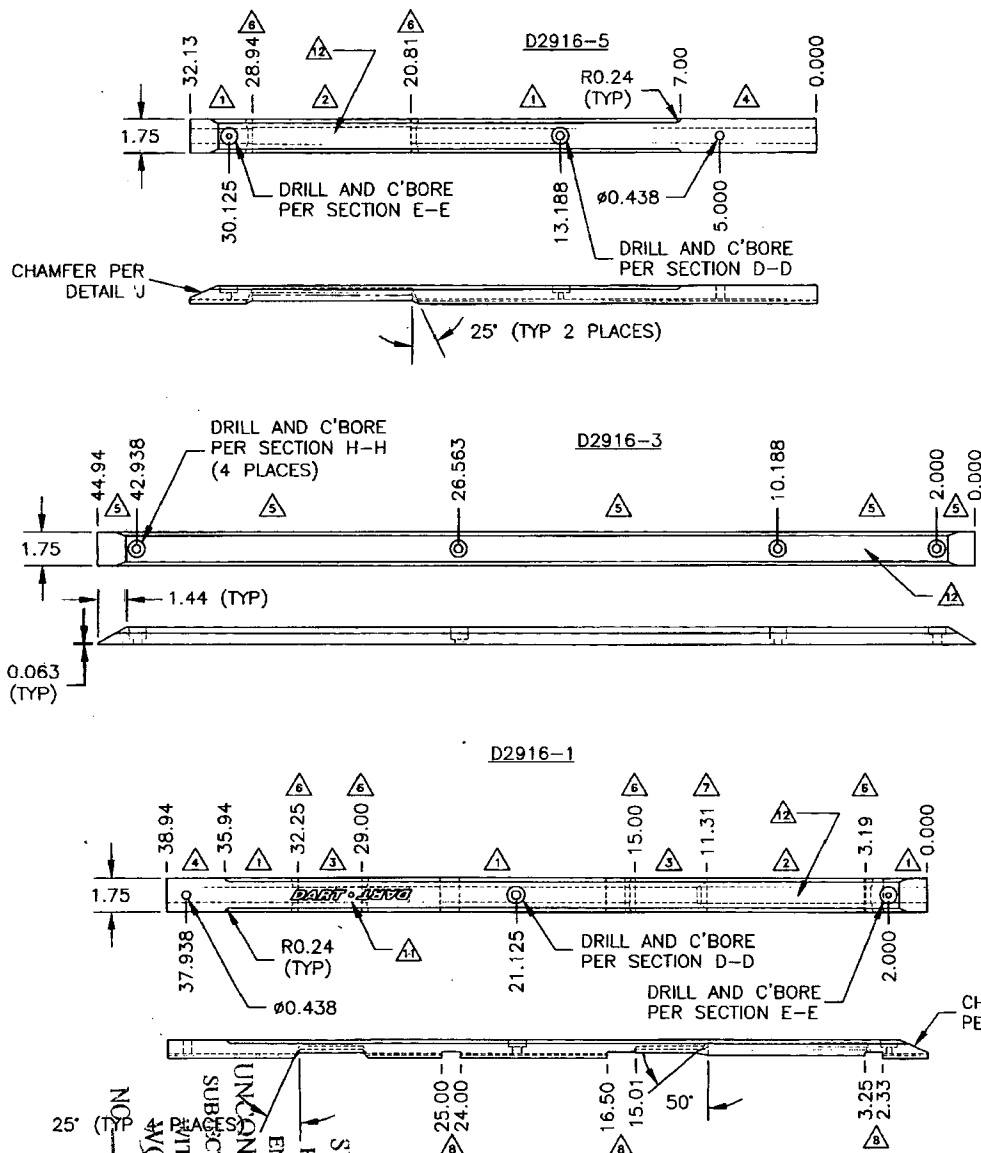
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WITHOUT NOTICE  
WORK ORDER  
NO. 39591



DETAIL J  
(SCALE 2:3)

RELEASED  
000.02.25 DS



- NOTES:
- 1) MACHINE CONSTANT SECTION A-A
  - 2) MACHINE CONSTANT SECTION B-B
  - 3) MACHINE CONSTANT SECTION C-C
  - 4) MACHINE CONSTANT SECTION F-F
  - 5) MACHINE CONSTANT SECTION G-G
  - 6) 25° ANGLE OF TRANSITION BETWEEN SECTIONS WITH MIN RADIUS OF 0.50
  - 7) 50° ANGLE OF TRANSITION BETWEEN SECTIONS WITH MIN RADIUS OF 0.50
  - 8) MACHINE SLOT PER SECTION K-K WITH 0.063 RADIUS OF TRANSITION BETWEEN SECTIONS
  - 9) MATERIAL: UHMW BLACK PER SPEC CONTROL DWG D2689
  - 10) BREAK ALL UNMARKED RADII 0.020 TO 0.040
  - 11) ENGRAVE TWO DART LOGOS (OPPOSITE AS SHOWN) ON UPPER SIDE TO MAX DEPTH OF 0.015 AND MIN RADIUS OF 0.250.
  - 12) ENGRAVE P/N ON LOWER SIDE TO MAX DEPTH OF 0.010 AND MIN RADIUS OF 0.010.
  - 13) ALL HOLES DRILLED ON CENTERLINES
  - 14) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 15) ALL DIMENSIONS ARE IN INCHES

RELEASED

DESIGN #	DRAWN BY	<b>DART</b> DART AEROSPACE LTD WILLOWDALE, ONTARIO, CANADA	REV. B
CHECKED #	APPROVED #	DRAWING NO. D2916	SHEET 2 OF 2
DATE 00.02.24		TITLE CABLE GUARD	SCALE 1:6

25° (TYP)  
NO. 38591  
WORK ORDER  
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